

U.S. DEPARTMENT OF COMMERCE, PATENT AND TRADEMARK OFFICE		DATE: June 22, 2001
TRANSMITTAL LETTER TO THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371		U.S. APPLN. NO. (if known): 09/857207
INTERNATIONAL APPLICATION NO.: PCT/JP00/07437	INTERNATIONAL FILING DATE: OCTOBER 24, 2000	PRIORITY DATE CLAIMED: OCTOBER 25, 1999
TITLE OF INVENTION: APPARATUS FOR DETECTING HEAT SEALED PLACES OF PLASTIC FILM MEANS		
APPLICANT(S) FOR DO/EO/US: Mikio TOTANI		
Applicant hereby submits to the United States Designated/Elected Office (DO/EO/US) the following items and other information:		
<p>1. <input checked="" type="checkbox"/> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371.</p> <p>2. <input type="checkbox"/> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371.</p> <p>3. <input checked="" type="checkbox"/> This express request to begin national examination procedures (35 USC 371(f)) at any time rather than delay examination until the expiration of the time limit set in 35 USC 371(b) and PCT Articles 22 and 39(1).</p> <p>4. <input type="checkbox"/> A proper Demand for International Preliminary Examination was made by the 19th month from the earliest claimed priority date.</p> <p>5. <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371(c)(2)):</p> <p style="margin-left: 40px;">a. <input type="checkbox"/> is transmitted herewith (required only if not transmitted by the International Bureau).</p> <p style="margin-left: 40px;">b. <input checked="" type="checkbox"/> has been transmitted by the International Bureau.</p> <p style="margin-left: 40px;">c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US).</p> <p>6. <input checked="" type="checkbox"/> A translation of the International Application into English (35 U.S.C. 371(c)(2)).</p> <p>7. <input checked="" type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371(c)(3))</p> <p style="margin-left: 40px;">a. <input type="checkbox"/> are transmitted herewith (required only if not transmitted by the International Bureau).</p> <p style="margin-left: 40px;">b. <input type="checkbox"/> have been transmitted by the International Bureau.</p> <p style="margin-left: 40px;">c. <input type="checkbox"/> have not been made; however, the time limit for making such amendments has NOT expired.</p> <p style="margin-left: 40px;">d. <input checked="" type="checkbox"/> have not been made and will not be made.</p> <p>8. <input type="checkbox"/> A translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371(c)(3)).</p> <p>9. <input type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)).</p> <p>10. <input type="checkbox"/> A translation of the annexes to the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)).</p> <p>ITEMS 11. TO 16. BELOW CONCERN OTHER DOCUMENT(S) OR INFORMATION INCLUDED:</p> <p>11. <input type="checkbox"/> An Information Disclosure Statement under 37 CFR 1.97 and 1.98.</p> <p>12. <input type="checkbox"/> An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included. ASSIGNEE NAME AND ADDRESS TOTANI CORPORATION, Kyoto-shi, Japan Please publish the assignee data with the application.</p> <p>13. <input checked="" type="checkbox"/> A FIRST preliminary amendment. <input type="checkbox"/> A SECOND or SUBSEQUENT preliminary amendment</p> <p>14. <input type="checkbox"/> A substitute specification.</p> <p>15. <input type="checkbox"/> A change of power of attorney and/or address letter.</p> <p>16. <input checked="" type="checkbox"/> Other items or information: 8 sheets of drawings.</p>		

U.S. APPLICATION NO. (if known) 09/857207		INTERNATIONAL APPLICATION NO. PCT/JP00/07437		DATE: June 22, 2001			
17. <u>X</u> The following fees are submitted: Basic National Fee (37 CFR 1.492(a)(1)-(5): Search Report has been prepared by the EPO or JPO: \$860.00 International preliminary examination fee paid to USPTO (37 CFR 1.482) \$690.00 No international preliminary examination fee paid to USPTO (37 CFR 1.482) but international search fee paid to USPTO (37 CFR 1.445(a)(2)) \$710.00 Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO \$1000.00 International preliminary examination fee (37 CFR 1.482) and all claims satisfied provisions of PCT Article 33(2)-(4) \$100.00 ENTER APPROPRIATE BASIC FEE AMOUNT = \$ 860.00				<u>CALCULATIONS</u>		<u>PTO USE ONLY</u>	
Surcharge of \$130.00 for furnishing the oath or declaration later than <u>x</u> 20 30 months from the earliest claimed priority date (37 CFR 1.492(e)).				\$ 130.00			
CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE				
TOTAL	48 - 20 =	28	X \$ 18.00	\$ 504.00			
INDEPENDENT	1 - 3 =		X \$ 80.00				
Multiple dependent claims(s) (if applicable)			+ \$270.00	\$ 270.00			
TOTAL OF ABOVE CALCULATIONS =				\$ 1,764.00			
Reduction by 1/2 for filing by small entity, if applicable. (Note 37 CFR 1.9, 1.27, 1.28).				\$ - 882.00			
SUBTOTAL =				\$ 882.00			
Processing fee of \$130.00 for furnishing the English translation later than ___ 20 30 months from the earliest claimed priority date (37 CFR 1.492(f)).				+			
TOTAL NATIONAL FEE =				\$ 882.00			
Fee for recording the enclosed assignment (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31). \$40.00 per property +							
TOTAL FEES ENCLOSED =				\$ 882.00			
				Amount to be:			
				refunded		\$	
				charged		\$	

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- a. ☒ A check in the amount of \$ 882.00 to cover the above fees is enclosed (small entity). (\$430.00 for basic filing fee; \$65.00 for late filing of the declaration; \$252.00 for 28 additional claims and \$135.00 for multiple dependent claims). (This paper is filed in triplicate)
- b. ☐ Please charge my Deposit Account No. 01-2340 in the amount of \$ to cover the above fees. (A duplicate copy of this sheet is enclosed.)
- c. ☒ The Commissioner is hereby authorized to charge any additional fees which may be required, or credit any overpayment to Deposit Account No. 01-2340.

NOTE: Where an appropriate time limit under 37 CFR 1.494 or 1.495 has not been met, a petition to revive (37 CFR 1.137(a) or (b)) must be filed to request that the application be restored to pending status.

Send All Correspondence To:



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PATENT TRADEMARK OFFICE

William L. Brooks By: 22,631
SIGNATURE

for: William L. Brooks
NAME

34,129
REGISTRATION NUMBER

WLB/yap

ARMSTRONG, WESTERMAN, HATTORI,
McLELAND & NAUGHTON, LLP
Suite 1000, 1725 K Street, N.W.
Washington, D. C. 20006
Tel: (202) 659-2930
Fax: (202) 887-0357

PATENT
IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re application of: **Mikio TOTANI**

Serial No.: **Not Yet Assigned**
(PCT/JP00/07437)

Filed: **June 22, 2001**

For: **APPARATUS FOR DETECTING HEAT SEALED PLACES OF
PLASTIC FILM MEANS**

PRELIMINARY AMENDMENT

Commissioner for Patents
Washington, D.C. 20231

June 22, 2001

Sir:

Prior to the calculation of the filing fees of the above application, please amend the application as follows:

IN THE ABSTRACT:

Please add the Abstract of the Disclosure attached on a separate page hereto.

IN THE CLAIMS:

Please amend claims 6-8, 11-13 and 16-18 as follows:

6. (Amended) The apparatus as set forth in any one of claims 1 to 3 wherein said plastic film means is fed longitudinally thereof and intermittently, said plastic film means being heat sealed widthwise thereof whenever intermittently fed, said optical sensor then detecting the heat sealed place of plastic film means whenever said plastic film means is intermittently fed, a cutter being disposed at a position and moved by position adjustment means to adjust the position of edge of

cutter in a direction parallel to the direction in which said plastic film means is fed, in response to a detecting signal transmitted from said optical sensor so that said plastic film means can be cut along a line predetermined at or near the heat sealed portion thereof by said cutter.

7. (Amended) The apparatus set forth in any one of claims 1 to 3 wherein said plastic film means is fed longitudinally thereof and intermittently for a length, said plastic film means being heat sealed widthwise thereof by seal bar means disposed at a position whenever said plastic film means is intermittently fed, said optical sensor then detecting the heat sealed place of plastic film means whenever said plastic film means is intermittently fed, to adjust the feed length of plastic film means or the position of heat seal bar means in response to a detecting signal transmitted from said optical sensor so that said plastic film means can be cut along a line predetermined at or near the heat sealed portion thereof by a cutter.

8. (Amended) The apparatus as set forth in any one of claims 1 to 3 wherein standing pouches are made from said plastic film means, each of the slanding pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite sides edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of

panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, whenever said panel and bottom materials are fed widthwise of the standing pouches and intermittently after being bottom and cross sealed in a standing pouch making process.

11. (Amended) The apparatus as set forth in claim 8 wherein punch holes are formed in said bottom material at intersections between the bottom and cross sealed portions, said layers of panel material being partially sealed with each other at the places of punch holes, said punch holes protruding from the cross sealed portions to have protruding portions formed on the opposite sides of the cross sealed portions, each of the protruding portions having a surface which is not or barely minutely rugged, said optical sensor judging whether the relation in place between the punch holes and the bottom and cross sealed portions is good or no good, in accordance with the place of protruding portion.

12. (Amended) The apparatus as set forth in clam 8 wherein said cross sealed portions have center lines along which notches are formed into the cross sealed portions from the bottom edges of panel material, said optical sensor judging whether the relation in place between the notches and the bottom and cross sealed portions is good or no good.

13. (Amended) the apparatus as set forth in any one of claims 1 to 3 wherein standing pouches are made from said plastic film means, each of the standing pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite side edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, when said standing pouches are fed widthwise thereof after being made.

16. (Amended) The apparatus as set forth in claim 13 wherein punch holes are formed in said bottom material at intersections between the bottom and cross sealed portions, said layers of panel material being partially sealed with each other at the places of punch holes, said punch holes protruding from the cross sealed portions to have protruding portions formed on the opposite sides of the cross sealed portions, each of the protruding portions having surface which is not or barely minutely rugged, said optical sensor judging whether the relation in place between the punch holes

and the bottom and cross sealed portions is good or no good, in accordance with the place at protruding portion.

wherein standing pouches are made from said plastic film means, each of the standing pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite side edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, when said standing pouches are fed widthwise thereof after being made.

17. (Amended) The apparatus as set forth in claim 13 wherein each of said standing pouches are corner cut at corners between the bottom and opposite side edges thereof to give an appearance, said optical sensor judging whether the appearance of corner cutting is good or no good.

18. (Amended) The apparatus as set forth in any one of claims 1 to 3 wherein standing pouches are made from said plastic film means, each of standing pouches comprising rectangular

panel materials which are superposed into two layers to have bottom and opposite side edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of cross sealed portions to judge whether the sealed width of cross sealed portion is good or no good, when said standing pouches are fed widthwise thereof after being made.

REMARKS

The above amendment is believed to place the claims in proper condition for examination.
Early and favorable action is awaited.

Attached hereto is a marked-up version of the changes made to the claims by the current amendment. The attached page is captioned "Version with markings to show changes made."

In the event there are any additional fees required, please charge our Deposit Account No. 01-2340.

Respectfully submitted,

ARMSTRONG, WESTERMAN, HATTORI,
MCLELAND & NAUGHTON, LLP

 Reg. No. 22,631

for, William L. Brooks
Reg. No. 34,129

Atty. Docket No. 010811
Suite 1000
1725 K Street, N.W.
Washington, D.C. 20006
Tel: (202) 659-2930
WLB/yap

Mikio TOTANI

Docket No. 010811

VERSION WITH MARKINGS TO SHOW CHANGES MADE

Claims 6-8, 11-13 and 16-18 have been amended as follows:

6. (Amended) The apparatus as set forth in any one of claims 1 to [5] 3 wherein said plastic film means is fed longitudinally thereof and intermittently, said plastic film means being heat sealed widthwise thereof whenever intermittently fed, said optical sensor then detecting the heat sealed place of plastic film means whenever said plastic film means is intermittently fed, a cutter being disposed at a position and moved by position adjustment means to adjust the position of edge of cutter in a direction parallel to the direction in which said plastic film means is fed, in response to a detecting signal transmitted from said optical sensor so that said plastic film means can be cut along a line predetermined at or near the heat sealed portion thereof by said cutter.

7. (Amended) The apparatus set forth in any one of claims 1 to [5] 3 wherein said plastic film means is fed longitudinally thereof and intermittently for a length, said plastic film means being heat sealed widthwise thereof by seal bar means disposed at a position whenever said plastic film means is intermittently fed, said optical sensor then detecting the heat sealed place of plastic film means whenever said plastic film means is intermittently fed, to adjust the feed length of plastic film means or the position of heat seal bar means in response to a detecting signal transmitted from said optical sensor so that said plastic film means can be cut along a line predetermined at or near the heat sealed portion thereof by a cutter.

8. (Amended) The apparatus as set forth in any one of claims 1 to [5] 3 wherein standing pouches are made from said plastic film means, each of the slanding pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite sides edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom

sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, whenever said panel and bottom materials are fed widthwise of the standing pouches and intermittently after being bottom and cross sealed in a standing pouch making process.

11. (Amended) The apparatus as set forth in [any one of claims 8 to 10] claim 8 wherein punch holes are formed in said bottom material at intersections between the bottom and cross sealed portions, said layers of panel material being partially sealed with each other at the places of punch holes, said punch holes protruding from the cross sealed portions to have protruding portions formed on the opposite sides of the cross sealed portions, each of the protruding portions having a surface which is not or barely minutely rugged, said optical sensor judging whether the relation in place between the punch holes and the bottom and cross sealed portions is good or no good, in accordance with the place of protruding portion.

12. (Amended) The apparatus as set forth in [any one of claims 8 to 11] claim 8 wherein said cross sealed portions have center lines along which notches are formed into the cross sealed portions from the bottom edges of panel material, said optical sensor judging whether the relation in place between the notches and the bottom and cross sealed portions is good or no good.

13. (Amended) the apparatus as set forth in any one of claims 1 to [5] 3 wherein standing pouches are made from said plastic film means, each of the standing pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite side edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, when said standing pouches are fed widthwise thereof after being made.

16. (Amended) The apparatus as set forth in [any one of claims 13 to 15] claim 13 wherein punch holes are formed in said bottom material at intersections between the bottom and cross sealed portions, said layers of panel material being partially sealed with each other at the places of punch holes, said punch holes protruding from the cross sealed portions to have protruding portions formed on the opposite sides of the cross sealed portions, each of the protruding portions having surface which is not or barely minutely rugged, said optical sensor judging whether the relation in place between the punch holes and the bottom and cross sealed portions is good or no good, in accordance with the place at protruding portion.

17. (Amended) The apparatus as set forth in [any one of claims 13 to 16] claim 13 wherein each of said standing pouches are corner cut at corners between the bottom and opposite side edges

thereof to give an appearance, said optical sensor judging whether the appearance of corner cutting is good or no good.

18. (Amended) The apparatus as set forth in any one of claims 1 to [5] 3 wherein standing pouches are made from said plastic film means, each of standing pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite side edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of cross sealed portions to judge whether the sealed width of cross sealed portion is good or no good, when said standing pouches are fed widthwise thereof after being made.

Specification

Apparatus for detecting heat sealed places of plastic film means

Technical field

The invention relates to an apparatus for detecting heat sealed places of plastic film means.

Background

For example, in a machine for successively making plastic bags, it is frequent practice to make plastic film means include heat sealed portions each of which has a surface minutely rugged to constitute a pattern such as a mesh. The plastic film means is then fed longitudinally thereof and intermittently, and cut along a line predetermined at or near the heat sealed portion by a cutter. In this case, it is required to cut the plastic film means precisely along a line predetermined at or near the heat sealed portion thereof. Accordingly, it is desirable to detect the heat sealed place of plastic film means whenever the plastic film means is fed longitudinally thereof and intermittently. Under the circumstances, the applicant proposed a new type of apparatus for detecting the heat sealed places of plastic film means, before this application, as disclosed in Japanese Laid-Open Patent Publication No. 190,608 of 1999.

In the apparatus of the publication, a light source and an optical sensor are opposed to the plastic film means so that the light source emits light which reflects from or permeates through the plastic film means to be directed to the optical sensor. The reflecting or permeating light is deflected by the minutely rugged surface of heat

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sealed portion to change the amount of light received by the optical sensor, when the heat sealed portion reaches a position at which the apparatus is disposed. As a result, there would appear a wave-shaped difference in amount of light received by the optical sensor in a direction perpendicular to the direction in which the plastic film means is fed. The optical sensor then reads out the minutely rugged surface of heat sealed portion from the wave of difference to detect the heat sealed place of the plastic film means. However, to tell the truth, the apparatus is uncertain to detect the heat sealed place to be problematic in reliability. This is considered as a matter due to the relation between the minutely rugged surface and the amount of light received by the optical sensor. Though the reflecting or permeating light is sure to be deflected by the minutely rugged surface, the deflected conditions are very complicated. It is therefore considered that the wave-shaped difference is not always brought into existence in amount of light received by the optical sensor, even if the reflecting or permeating light is deflected. In such the case, the apparatus can not read out the minutely rugged surface of heat sealed portion from the wave of difference to detect the heat sealed place of plastic film means.

It is therefore an object of the invention to reliably detect the heat sealed places of plastic film.

Disclosure of the invention

According to the invention, there is provided an apparatus for detecting heat sealed places of plastic film means which is fed in a direction. The plastic film means includes heat sealed portions formed at the heat sealed places. Each of the heat sealed portions has a

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surface minutely rugged to constitute a pattern such as a mesh. In addition, light source means and an optical sensor are opposed to the plastic film means. A cover plate is disposed between the optical sensor and the plastic film means. The cover plate includes small hole or narrow slit means through which light passes. The light source means emits light which reflects from or permeates through the plastic film means to be directed to the optical sensor. The optical sensor image recognizes the reflecting or permeating light and reads out the minutely rugged surface of heat sealed portion to detect the heat sealed place of plastic film means in accordance with a variation of image.

It is preferable that the light source means comprises a plurality of light sources spaced from each other and opposed to the plastic film means.

It is also preferable that the light sources are spaced from each other in directions parallel and perpendicular to the direction in which the plastic film means is fed.

In addition, it is preferable that the small hole or narrow slit means comprises a plurality of small holes or narrow slits formed in the cover plate to be spaced from each other.

Furthermore, it is preferable that the small holes or narrow slits are spaced from each other in directions parallel and perpendicular to the direction in which the plastic film means is fed.

In a preferred embodiment, the plastic film means is fed longitudinally thereof and intermittently. In addition, the plastic film means is heat sealed widthwise thereof whenever intermittently fed. The optical sensor then detects the heat sealed place of plastic film means whenever the plastic film means is intermittently fed. A cutter is disposed at a position and moved by position adjustment means

bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, whenever the panel and bottom materials are fed widthwise of the standing pouches and intermittently after being bottom and cross sealed in a standing pouch making process.

It is preferable that each of the bottom sealed portions includes unsealed portions formed therein. Each of the unsealed portions has a surface which is not or barely minutely rugged. In the case, the optical sensor can judge whether the relation in place between the bottom and cross sealed portions is good or no good, in accordance with the place of unsealed portion.

It is preferable that each of the bottom sealed portions has a bowl-shaped upper edge. In the case, the optical sensor can judge whether the relation in place between the bottom and cross sealed portions is good or no good, in accordance with the place of bowl-shaped upper edge.

It is preferable that punch holes are formed in the bottom material at intersections between the bottom and cross sealed portions. The layers of panel material are partially sealed with each other at the places of punch holes. The punch holes protrude from the cross sealed portions to have protruding portions formed on the opposite sides of the cross sealed portions. Each of the protruding portions has a surface which is not or barely minutely rugged. In the case, the optical sensor can judge whether the relation in place between the punch holes and the bottom and cross sealed portions is good or no good, in accordance with the place of protruding portion.

It is preferable that the cross sealed portions have center lines along which notches are formed into the cross sealed portions from

the bottom edges of panel material. In the case, the optical sensor can judge whether the relation in place between the notches and the bottom and cross sealed portions is good or no good.

In other embodiment, the optical sensor reads out the minutely rugged surfaces of bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, when the standing pouches are fed widthwise thereof after being made.

In the embodiment, each of the bottom sealed portions may include an unsealed portion formed therein. In the case, the optical sensor can judge whether the relation in place between the bottom and cross sealed portions is good or no good, in accordance with the place of unsealed portion.

Each of the bottom sealed portions may have a bowl-shaped upper edge. In the case, the optical sensor can judge whether the relation in place between the bottom and cross sealed portions is good or no good, in accordance with the place of bowl-shaped upper edge.

Punch holes may be formed in the bottom material at intersections between the bottom and cross sealed portions. The punch holes may protrude from the cross sealed portions to have protruding portions formed on the opposite sides of the cross sealed portions. In the case, the optical sensor can judge whether the relation in place between the punch holes and the bottom and cross sealed portions is good or no good, in accordance with the place of protruding portion.

It is preferable that each of the standing pouches are corner cut at corners between the bottom and opposite side edges thereof to give an appearance. In the case, the optical sensor can judge whether the appearance of corner cutting is good or no good.

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In other embodiment, the optical sensor reads out the minutely rugged surfaces of cross sealed portions to judge whether the sealed width of cross sealed portion is good or no good, when the standing pouches are fed widthwise thereof after being made.

Brief description of the drawings

Fig. 1 is a side view of a preferred embodiment of the invention.

Fig. 2 is a plan view of the plastic film means of Fig. 1.

Fig. 3 is a side view of the apparatus for detecting the heat sealed place of Fig. 1.

Fig. 4 is a bottom view of the cover plate of Fig. 3.

Fig. 5 is an explanatory view of images obtained by the optical sensor of Fig. 3.

Fig. 6 is an explanatory view showing the disturbed images of reflecting lights of Fig. 5.

Fig. 7 is a side view of other embodiment.

Fig. 8 is a bottom view of the cover plate of Fig. 7.

Fig. 9 is a side view of other embodiment.

Fig. 10 is a plan view of other embodiment.

Fig. 11 is an enlarged view of the panel and bottom materials of Fig. 10.

Fig. 12 is a plan view of other embodiment.

Fig. 13 is a side view of other embodiment.

Fig. 14 is an explanatory view of images obtained by the optical sensor of Fig. 13.

Fig. 15 is a bottom view of other embodiment.

Fig. 16 is an explanatory view of images of the embodiment of

Fig. 15.

Fig. 17 is a side view of other embodiment.

Fig. 18 is a side view of other embodiment.

The best mode to be carry out the invention.

Referring now to the drawings. Fig. 1 illustrates an apparatus 2 for detecting heat sealed places according to the invention. The apparatus 2 is intended to detect heat sealed places of plastic film means 4 which is fed in a direction X. In the embodiment, the apparatus 2 is incorporated into a machine for successively making plastic bags. The plastic film means 4 comprises plastic films superposed into two layers. The plastic films 4 pass through longitudinal seal bars 6 and cross seal bars 8 to be directed between a pair of feed rollers 10 which are rotated by a drive motor so that the plastic films 4 can be fed longitudinally X thereof and intermittently. The longitudinal seal bars 6 and cooling bars 12 are operated by a drive motor so that the plastic films 4 can be heat sealed longitudinally X thereof and cooled by the cooling bars 12, whenever intermittently fed, to include heat sealed portions 14 formed therein, as shown in Fig. 2. The cross seal bars 8 and cooling bars 16 are operated by the drive motor so that the plastic films 4 can be heat sealed widthwise thereof and cooled by the cooling bars 16, whenever intermittently fed, to include heat sealed portions 18 formed at the heat sealed places. A cutter 20 is then operated by the drive motor so that the plastic films 4 can be cut along a line predetermined at or near the heat sealed portion 18 by the cutter 20, whenever intermittently fed. In the embodiment, the plastic films 4 are cut along the center line 21 of heat sealed portion 18, to thereby successively make plastic bags 22. As to the heat sealed portion

18, the cross seal bars 8 or the cooling bars 16 include Teflon sheets or minutely rugged surfaces which are pressed against the heat sealed portions 18 to make each of the heat sealed portions 18 have a surface minutely rugged to constitute a pattern such as a mesh.

The apparatus 2 includes light source means 23, an optical sensor 24 and a cover plate 26, as shown in Fig. 3. The light source means 23 and the optical sensor 24 are opposed to the plastic films 4 on the upper side of the plastic films 4 at a position downstream of the cross seal bars 8 and the cooling bars 16 and upstream of the cutter 20. The cover plate 26 is disposed between the optical sensor 24 and the plastic films 4. The optical sensor 24 comprises a CCD camera. The cover plate 26 includes small hole means 28 through which light passes, as shown in Fig. 4. Accordingly, the light source means 23 emits light which reflects from the plastic films 4 and then passes through the small hole means 28 to be directed to the optical sensor 24 so that the optical sensor 24 can image recognize the reflecting light.

The light source means 23 comprises a plurality of light sources spaced from each other and opposed to the plastic films 4 to emit a plurality of lights which reflect from the plastic film 4 at angles different from each other and then passes through the small hole means 28 to be directed to the optical sensor 24 so that the optical sensor 24 can image recognize them. For example, two light sources 23 are spaced from each other in a direction parallel to the direction in which the plastic films 4 are fed. The lights therefore reflect from the plastic films 4 at angles α and β different from each other and then pass through the small hole means 28 to be directed to the optical sensor 24 so that the optical sensor 24 can image recognize them.

In addition, the small hole means comprises a plurality of small

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holes 28 formed in the cover plate 26 to be spaced from each other. For example, four small holes 28 are formed in the cover plate 26 and spaced from each other in directions parallel and perpendicular to the direction in which the plastic films 4 are fed, to be arranged squarely at a pitch P1 of 5 to 20 mm. Each of the small holes 28 comprises a circular hole having a diameter of 0.1 to 5.0 mm. Accordingly, the reflecting lights pass through four small holes 28 to be directed to the optical sensor 24. The optical sensor 24 can therefore image recognize two reflecting lights 29 per small hole 28, or eight reflecting lights 29 in total, as shown in Fig. 5.

Furthermore, the reflecting lights are deflected by the minutely rugged surface of heat sealed portion 18 when the plastic films 4 are fed longitudinally X thereof and the heat sealed portion 18 reaches the position at which the apparatus 2 is disposed. Accordingly, the reflecting lights then pass thorough the small holes 28 of cover plate 26 to be directed to the optical sensor 24 so that the images of reflecting lights 29 are remarkably disturbed and changed, as shown in Fig. 6. The detector 24 can therefore read out the minutely rugged surface of heat sealed portion 18 to detect the heat sealed place of plastic films 4 in accordance with a variation of image. In addition, the optical sensor 24 can image recognize eight reflecting lights 29 in total, as described above, to read out the minutely rugged surface of heat sealed portion 18 by any one of the images of reflecting lights 29 remarkably disturbed and changed. The apparatus can therefore reliably detect the heat sealed places of plastic films 4 without difficulty.

In the embodiment, the optical sensor 24 is spaced from the plastic films 4 at a distance of 200 mm in view of the diameter of 0.1 to 5.0 mm of each of the small holes 28. When increasing the distance

between the optical sensor 24 and the plastic films 4, it is preferable to increase the diameters of the small holes 28 in proportion to that distance.

Furthermore, in the embodiment, the plastic films 4 are heat sealed widthwise thereof whenever intermittently fed, as described above. The optical sensor 24 then detects the heat sealed place of plastic films 4 whenever the plastic films 4 are intermittently fed. In addition, the cutter 20 is disposed at a position and moved by position adjustment means to adjust the position of edge of cutter 20 in a direction parallel to the direction in which the plastic films 4 are fed, in response to a detecting signal transmitted from the optical sensor 24. The position adjustment means comprises a ball screw 30 threadedly engaged with a frame 32 and connected to a drive motor 34, the cutter 20 being supported on the frame 32. The apparatus 2 is connected to a control device 35 which is connected to the drive motor 34. The ball screw 30 is therefore rotated by the drive motor 34 driven by the control device 35 so that the cutter 20 and the frame 32 can be moved in a direction parallel to the direction X in which the plastic films 4 are fed, to adjust the position of edge of cutter 20 in response to a detecting signal transmitted from the detector 24 detecting the heat sealed place, whenever the plastic film 4 are intermittently fed after heat sealed. Accordingly, the plastic films 4 can then be cut along the line predetermined at or near the heat sealed portion 18 by the cutter 20.

The apparatus can therefore cut the plastic films 4 precisely along the center line 21 of heat sealed portion 18. As a result, the apparatus can diminish the sealed width SW of heat sealed portion 18 and therefore lower the material cost of plastic films 4. It has been

plastic film 4 are fed, and then pass through the small holes 28 to be directed to the optical sensor 24. The optical sensors 24 can therefore image recognize four reflecting lights per small hole 28, or 36 reflecting lights in total.

In the embodiment in which the light sources 23 are spaced from each other in directions parallel and perpendicular to the direction X in which the plastic films 4 are fed, to be arranged squarely, it should therefore be noted that the number of light sources 23 doubles the number of reflecting lights which the optical sensors 24 can image recognize, to reliably read out the minutely rugged surface of heat sealed portion 18 without difficulty. In the embodiment in which the small holes 28 are spaced from each other in directions parallel and perpendicular to the direction X in which the plastic films 4 are fed, to be latticed, it should also be noted that the number of small holes 28 doubles the number of reflecting lights which the optical sensors 24 can image recognize, to reliably read out the minutely rugged surface of heat sealed portion 18 without difficulty. Accordingly, the apparatus can reliably detect the heat sealed places of plastic films 4 without difficulty.

In the embodiment of Fig. 7, the lights reflect from the plastic films 4 and pass through the small holes 28 of cover plate 26 to be directed to the optical sensor 24 in a direction nearly vertical to the plastic films 4. The images of reflecting lights are therefore preferably kept from being disturbed regardless of a certain fluctuation in height of plastic films 4.

The cover plate 26 may include not the small hole means 28 but narrow slit means formed therein so that light reflects the plastic films 4 and passes through the narrow slit means to be directed to the

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with one of the layers of bottom material 42 to include a bottom sealed portion 44 formed along the bottom edge 40 of panel material 38. The other layer of panel material 38 is bottom sealed with the other layer of bottom material 42 to include a bottom sealed portion 44 formed along the bottom edge 40 of panel material 38. In addition, the layers of panel material 38 are cross sealed with each other to include cross sealed portions 48 formed along the opposite side edges 46 of panel material 38. The panel and bottom materials 38 and 42 comprise the plastic films. Each of the bottom and cross sealed portions 44 and 48 has the minutely rugged surface.

In a process of making the standing pouches 36, the panel and bottom materials 38 and 42 are bottom sealed by bottom seal bars and cooled by cooling bars. In addition, the panel and bottom materials 38 and 42 are cross sealed by cross sealed bars and cooled by cooling bars. The panel and bottom materials 38 and 42 are then fed widthwise X of the standing pouches 36. Furthermore, the panel and bottom materials 38 and 42 are cut along the center line of the cross sealed portion 48 so that the opposite side edges 46 can be formed. The bottom and cross seal bars or the cooling bars include Teflon sheets or minutely rugged surfaces which are pressed against the panel materials 38 when bottom and cross sealed or cooled, to make each of the bottom and cross sealed portions 44 and 48 have the minutely rugged surface.

In this case, the panel and bottom materials 38 and 42 are not always precisely bottom and cross sealed. The relation in place between the bottom and cross sealed portions 44 and 48 is therefore not always good. Under the circumstances, in the embodiment, the apparatus 2 is arranged similarly to the above embodiments to include the light sources 23, the optical sensor 24 and the cover plate 25 disposed on the

upper or lower side of the panel and bottom materials 38 and 42 when the panel and bottom materials 38 and 42 are fed widthwise X of the standing pouches 36 and intermittently after being bottom and cross sealed in the standing pouch making process. The optical sensor 24 can therefore read out the minutely rugged surface of bottom and cross sealed portions 44 and 48 to judge whether the relation in place between the bottom and cross sealed portions 44 and 48 is good or no good. A proper measure can therefore be taken when the panel and bottom materials 38 and 42 are not precisely bottom and cross sealed. For example, a device may be arranged to generate an alarm sound or light or discharge the panel and bottom materials 38 and 42.

In this connection, the cross sealed portion 48 are formed along the opposite side edges 46 to extend in a direction perpendicular to the direction X in which the panel and bottom materials 38 and 42 are fed widthwise of the standing pouches 36. In addition, unlike the cross sealed portion 48 of standing pouch 36, the non-sealed portion has a surface which is not minutely rugged so that the images of reflecting lights are not disturbed and changed when the lights reflect from the non-sealed portion and pass through the small holes 28 of cover plate 26 to be directed to the optical sensor 24. In contrast, as to the cross sealed portion 48, the images of reflecting lights are remarkably disturbed and changed when the lights reflect from the cross sealed portion 48 and pass through the small holes 28 of cover plate 26 to be directed to the optical sensor 24. The optical sensor 24 can therefore detect the cross sealed portion 48 or the cross sealed place.

On the other hand, the bottom sealed portions 44 are formed along the bottom edges 40 of panel material 38 to extend in a direction parallel to the direction in which the panel and bottom materials 38 and

42 are fed. However, in general, each of the bottom sealed portions 44 includes unsealed portions 50 formed therein, as shown in Fig. 11. Each of the unsealed portions 50 has a surface which is not or barely minutely rugged. The term "barely minutely rugged" means here to be at least less minutely rugged than the bottom and cross sealed portions 44 and 48. In this case, the images of reflecting lights are remarkably disturbed and changed when the lights reflect from the bottom sealed portion 44 and pass through the small holes 28 of cover plate 26 to be directed to the optical sensor 24. In contrast, the images of reflecting lights are not disturbed and changed when the lights reflect from the unsealed portion 50 and pass through the small holes 28 of cover plate 26 to be directed to the optical sensor 24. The optical sensor 24 can therefore detect the bottom sealed portion 44 or the bottom sealed place and judge whether the relation in place between the bottom and cross sealed portions 44 and 48 is good or no good, in accordance with the place of unsealed portion 50.

In the case of standing pouch 36, each of the bottom sealed portions 44 has a bowl-shaped upper edge 52 which extends obliquely to the direction in which the panel and bottom materials 38 and 42 are fed. The optical sensor 24 can therefore detect the place of bowl-shaped upper edge 52 and judge whether the relation in place between the bottom and cross sealed portions 44 and 48 is good or no good, in accordance with the place of bowl-shaped upper edge 52.

Furthermore, punch holes 54 are formed in the bottom material 42 at intersections between the bottom and cross sealed portions 44 and 48. The layers of panel material 38 are partially sealed with each other at the places of punch holes 54. The punch holes 54 protrude from the cross sealed portions 48 to have protruding portions 56 formed on the

opposite sides of the cross sealed portions 48. Each of the protruding portions 56 has a surface which is not or barely minutely rugged. The term "barely minutely rugged" means here to be at least less minutely rugged than the bottom and cross sealed portions 44 and 48. The optical sensor 24 can therefore detect the place of protruding portion 56 and judge whether the relation in place between the punch holes 54 and the bottom and cross sealed portions 44 and 48 is good or no good, in accordance with the place of protruding portion 56.

It is also usual that the cross sealed portions 48 have center lines along which notches 58 are formed into the cross sealed portions 48 from the bottom edges 40 of panel material 38. The notches 58 are intended to make the standing pouches 36 corner cut. The standing pouches 36 are corner cut at corners between the bottom and opposite side edges 40 and 46 when the panel and bottom materials 38 and 42 are cut along the center lines of cross sealed portions 48. In this case, the optical sensor 24 can detect the places of notches 58 and judge whether the relation in place between the notches 58 and the bottom and cross sealed portions 44 and 48 is good or no good.

The apparatus may be arranged that the optical sensor 24 reads out the minutely rugged surfaces of bottom and cross sealed portions 44 and 48 when the standing pouches 36 are fed widthwise X thereof after being made, as shown in Fig. 12. The optical sensor 24 can therefore judge whether the relation in place between the bottom and cross sealed portion is good or no good, as in the case of the embodiment of Fig. 10.

In the embodiment of Fig. 12, the apparatus may be arranged that the optical sensor 24 judges whether the relation in place between the bottom and cross sealed portions 44 and 48 is good or no good, in accordance with the place of unsealed portion 50. The apparatus may also

be arranged that the optical sensor 24 judges whether the relation in place between the punch holes 54 and the bottom and cross sealed portions 44 and 48 is good or no good, in accordance with the place of protruding portion 56. In the case of each of standing pouches 36 corner cut at corners between the bottom and opposite side edges 40 and 46 thereof to give an appearance, the apparatus may be arranged that the optical sensor 24 judges whether the appearance of corner cutting is good or no good.

In addition, the apparatus may be arranged that the optical sensor 24 reads out the minutely rugged surfaces of cross sealed portions 48 to judge whether the sealed width of cross sealed portion 48 is good or no good, when the standing pouches 36 are fed widthwise X thereof after being made.

In the case of a plurality of light sources 23 opposed to the plastic films 4, a plurality of small holes 28 have not always to be formed in the cover plate 26. Even with a single small holes 28, the number of light sources 23 doubles the number of reflecting lights which the optical sensor 24 can image recognize, to read out the minutely rugged surface of heat sealed portion 18 in accordance with the variation of image.

By contraries, in the case of a plurality of small holes 28 formed in the cover plate 26, a plurality of light sources 23 have not always to be opposed to the plastic films 4. Even with a single light source 23, it emits light which reflects from or permeates through the plastic films 4 and passes through the small holes 28 to be directed to the optical sensor 24, as shown in Fig. 13, so that the number of small holes 28 doubles the number of reflecting or permeating lights which the optical sensor 24 can image recognize, to read out the minutely rugged

surface of heat sealed portion 18 in accordance with the variation of image.

In the embodiment of Fig. 13, the apparatus includes the same cover plate 26 as that of Fig. 4 in which four small holes 28 are spaced from each other in directions parallel and perpendicular to the direction X in which the plastic films 4 are fed. The apparatus can therefore image recognize four reflecting or permeating lights in total. In addition, the images of reflecting or permeating lights are remarkably disturbed and changed, as shown in Fig. 14, when the light reflects from or permeates through the minutely rugged surface of heat sealed portion 18 and passes through the small holes 28 of cover plate 26 to be directed to the optical sensor 24. The apparatus can therefore read out the minutely rugged surface of heat sealed portion 18 to detect the heat sealed place of plastic films 4.

In the case of narrow slit means formed in the cover plate 26, even with a single light source 23, it emits light which reflects from or permeates through the plastic films 4 and passes through the narrow slit means of cover plate 26 to be directed to the optical sensor 24 so that the optical sensor 24 can image recognize the reflecting or permeating light and read out the minutely rugged surface of heat sealed portion 18 to detect the heat sealed place of plastic films 4 in accordance with a variation of image. In the case, it is preferable that the narrow slit means extends in a direction parallel to the direction X in which the plastic films 4 are fed.

In other embodiment of Fig. 15, the narrow slit means comprises a plurality of narrow slits 60 formed in the cover plate 26, having a width W and extending in a direction parallel to the direction X in which the plastic films 4 are fed. The narrow slits 60 are spaced from

each other in a direction perpendicular to the direction X in which the plastic films 4 are fed. Accordingly, the images of reflecting or permeating lights 61 are remarkably disturbed and changed, as shown in Fig. 16, when the light reflects from or permeates through the minutely rugged surface of heat sealed portion 18 and passes through the narrow slits 60 of cover plate 26 to be directed to the optical sensor 24. The apparatus can therefore read out the minutely rugged surface of heat sealed portion 18 to detect the heat sealed place of plastic films 4.

In the embodiment, each of the narrow slits 60 have the width W of 0.1 to 5.0 mm. The optical sensor 24 is spaced from the plastic films 4 at a distance of about 200 mm. When increasing the distance between the optical sensor 24 and the plastic films 4, it is preferable to increase the width W of each of the narrow slits 60 in proportion to that distance.

In each of the embodiments described above, a lens 62 may be disposed between the optical sensor 24 and the cover plate 26 so that the images of reflecting or permeating lights can be made clear by the lens 62, as shown in Fig. 17. The cover plate 26 may be disposed between the optical sensor 24 and the lens 62 so that the images of reflecting or permeating lights can be made clear by the lens 62. A lens may be incorporated into the small holes 28 or the narrow slits 60 of cover plate 26.

Claims

1. An apparatus for detecting heat sealed places of plastic film means which is fed in a direction, said plastic film means including heat sealed portions formed at the heat sealed places, each of the heat sealed portions having a surface minutely rugged to constitute a pattern such as a mesh, said apparatus comprising:

- light source means opposed to said plastic film means;
- an optical sensor opposed to said plastic film means; and
- a cover plate disposed between said optical sensor and said plastic film means, said cover plate including small hole or narrow slit means through which light passes, said light source means emitting light which reflects from or permeates through said plastic film means and then passes through said small hole or narrow slit means to be directed to said optical sensor, said optical sensor image recognizing the reflecting or permeating light and reading out the minutely rugged surface of heat sealed portion to detect the heat sealed place of plastic film means in accordance with a variation of image.

2. The apparatus as set forth in claim 1 wherein said light source means comprises a plurality of light sources spaced from each other and opposed to said plastic film means.

3. The apparatus as set forth in claim 2 wherein said light sources are spaced from each other in directions parallel and perpendicular to the direction in which said plastic film means is fed.

4. The apparatus as set forth in any one of claims 1 to 3

wherein said small hole or narrow slit means comprises a plurality of small holes or narrow slits formed in said cover plate to be spaced from each other.

5. The apparatus as set forth in claim 4 wherein said small holes or narrow slits are spaced from each other in directions parallel and perpendicular to the direction in which said plastic film means is fed.

6. The apparatus as set forth in any one of claims 1 to 5 wherein said plastic film means is fed longitudinally thereof and intermittently, said plastic film means being heat sealed widthwise thereof whenever intermittently fed, said optical sensor then detecting the heat sealed place of plastic film means whenever said plastic film means is intermittently fed, a cutter being disposed at a position and moved by position adjustment means to adjust the position of edge of cutter in a direction parallel to the direction in which said plastic film means is fed, in response to a detecting signal transmitted from said optical sensor so that said plastic film means can be cut along a line predetermined at or near the heat sealed portion thereof by said cutter.

7. The apparatus as set forth in any one of claims 1 to 5 wherein said plastic film means is fed longitudinally thereof and intermittently for a length, said plastic film means being heat sealed widthwise thereof by seal bar means disposed at a position whenever said plastic film means is intermittently fed, said optical sensor then detecting the heat sealed place of plastic film means whenever said

plastic film means is intermittently fed, to adjust the feed length of plastic film means or the position of heat seal bar means in response to a detecting signal transmitted from said optical sensor so that said plastic film means can be cut along a line predetermined at or near the heat sealed portion thereof by a cutter.

8. The apparatus as set forth in any one of claims 1 to 5 wherein standing pouches are made from said plastic film means, each of the standing pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite side edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, whenever said panel and bottom materials are fed widthwise of the standing pouches and intermittently after being bottom and cross sealed in a standing pouch making process.

9. The apparatus as set forth in claim 8 wherein each of said

bottom sealed portions includes unsealed portions formed therein, each of said unsealed portions having a surface which is not or barely minutely rugged, said optical sensor judging whether the relation in place between the bottom and cross sealed portions is good or no good, in accordance with the place of unsealed portion.

10. The apparatus as set forth in claim 8 wherein each of said bottom sealed portions has a bowl-shaped upper edge, said optical sensor judging whether the relation in place between the bottom and cross sealed portions is good or no good, in accordance with the place of bowl-shaped upper edge.

11. The apparatus as set forth in any one of claims 8 to 10 wherein punch holes are formed in said bottom material at intersections between the bottom and cross sealed portions, said layers of panel material being partially sealed with each other at the places of punch holes, said punch holes protruding from the cross sealed portions to have protruding portions formed on the opposite sides of the cross sealed portions, each of the protruding portions having a surface which is not or barely minutely rugged, said optical sensor judging whether the relation in place between the punch holes and the bottom and cross sealed portions is good or no good, in accordance with the place of protruding portion.

12. The apparatus as set forth in any one of claims 8 to 11 wherein said cross sealed portions have center lines along which notches are formed into the cross sealed portions from the bottom edges of panel material, said optical sensor judging whether the relation in

place between the notches and the bottom and cross sealed portions is good or no good.

13. The apparatus as set forth in any one of claims 1 to 5 wherein standing pouches are made from said plastic film means, each of the standing pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite side edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of bottom and cross sealed portions to judge whether the relation in place between the bottom and cross sealed portions is good or no good, when said standing pouches are fed widthwise thereof after being made.

14. The apparatus as set forth in claim 13 wherein each of said bottom sealed portions includes an unsealed portion formed therein, said unsealed portion having a surface which is not or barely minutely rugged, said optical sensor judging whether the relation in place between the bottom and cross sealed portions is good or no good, in

accordance with the place of unsealed portion.

15. The apparatus as set forth in claim 13 wherein each of said bottom sealed portions has a bowl-shaped upper edge, said optical sensor judging whether the relation in place between the bottom and cross sealed portions is good or no good, in accordance with the place of bowl-shaped upper edge.

16. The apparatus as set forth in any one of claims 13 to 15 wherein punch holes are formed in said bottom material at intersections between the bottom and cross sealed portions, said layers of panel material being partially sealed with each other at the places of punch holes, said punch holes protruding from the cross sealed portions to have protruding portions formed on the opposite sides of the cross sealed portions, each of the protruding portions having a surface which is not or barely minutely rugged, said optical sensor judging whether the relation in place between the punch holes and the bottom and cross sealed portions is good or no good, in accordance with the place of protruding portion.

17. The apparatus as set forth in any one of claims 13 to 16 wherein each of said standing pouches are corner cut at corners between the bottom and opposite side edges thereof to give an appearance, said optical sensor judging whether the appearance of corner cutting is good or no good.

18. The apparatus as set forth in any one of claims 1 to 5 wherein standing pouches are made from said plastic film means, each of

the standing pouches comprising rectangular panel materials which are superposed into two layers to have bottom and opposite side edges, a bottom material being folded into halves, superposed into two layers and interposed between the layers of panel material at the bottom edges thereof, one of said layers of panel material being bottom sealed with one of said layers of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, the other layer of panel material being bottom sealed with the other layer of bottom material to include a bottom sealed portion formed along the bottom edge of panel material, said layers of panel material being cross sealed with each other to include cross sealed portions formed along the opposite side edges of panel material, each of the bottom and cross sealed portions having the minutely rugged surface, said optical sensor reading out the minutely rugged surfaces of cross sealed portions to judge whether the sealed width of cross sealed portion is good or no good, when said standing pouches are fed widthwise thereof after being made.

Fig. 1

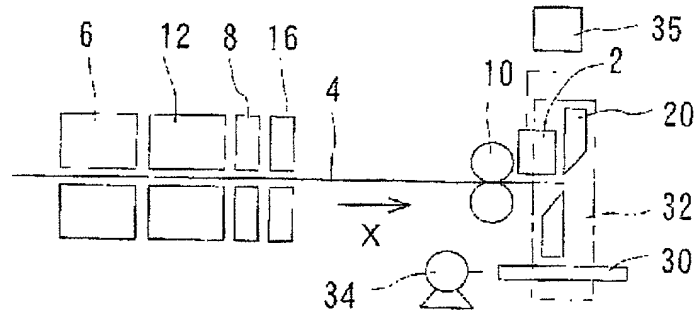


Fig. 2

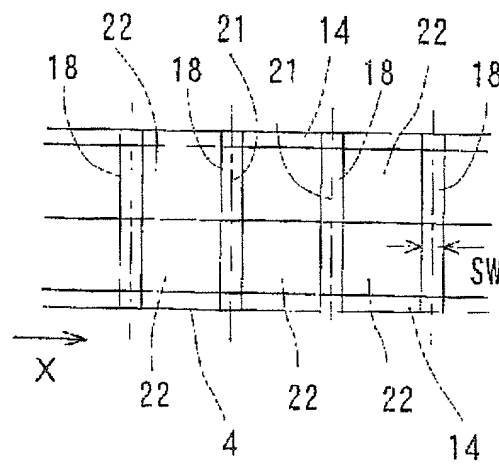


Fig. 3

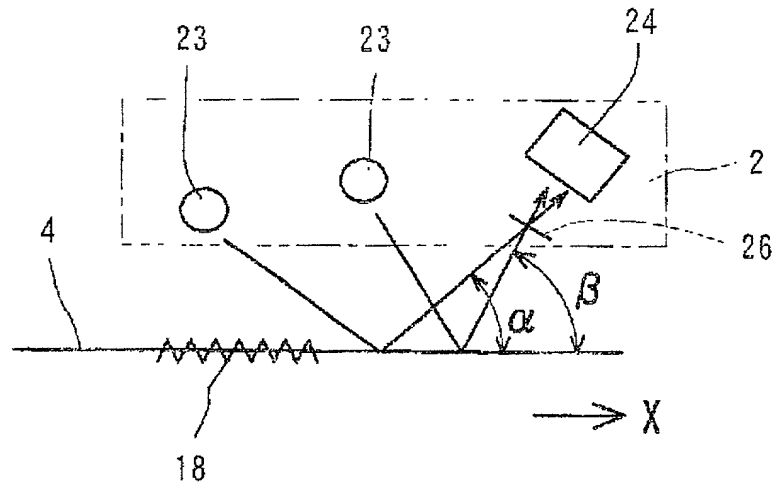
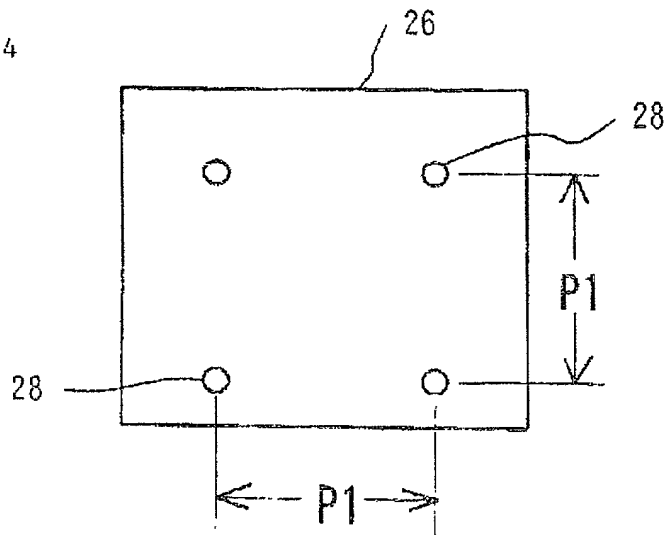


Fig. 4



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Fig. 5

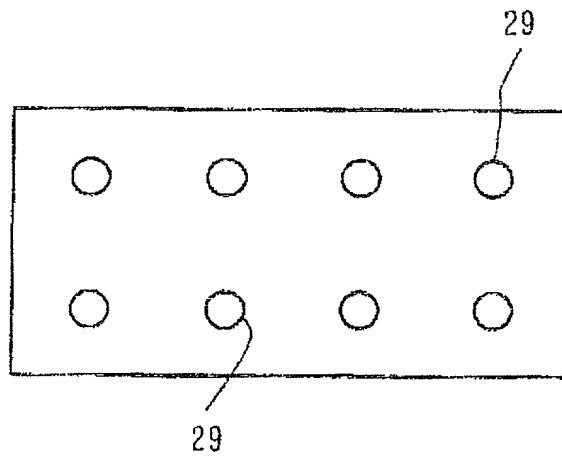
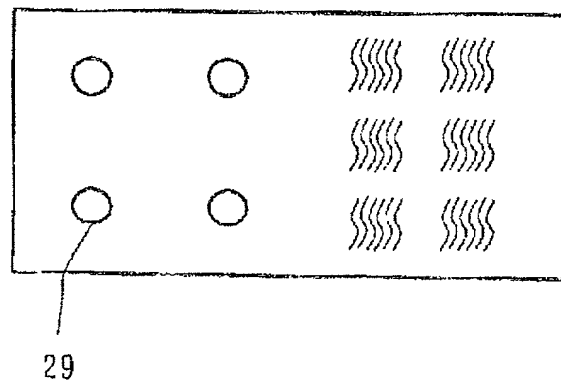


Fig. 6



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Fig. 7

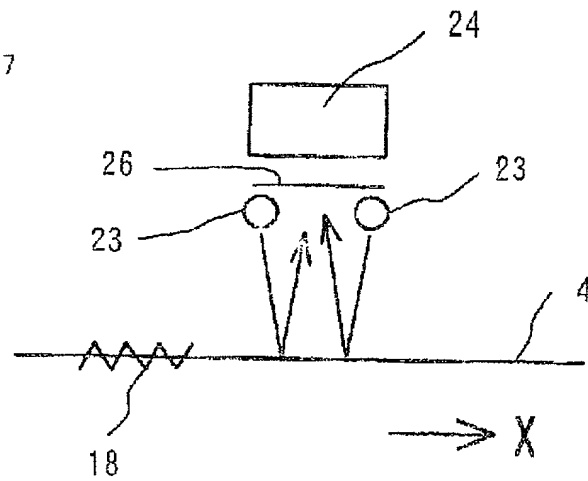
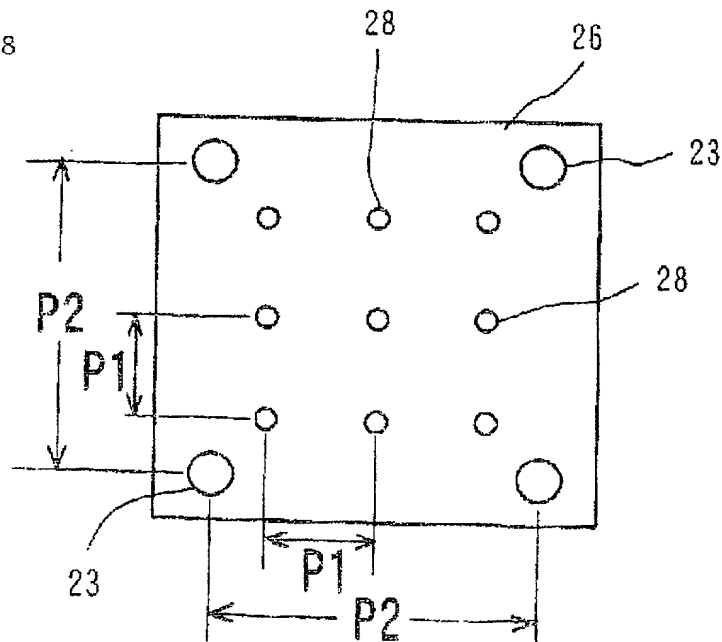


Fig. 8



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Fig. 9

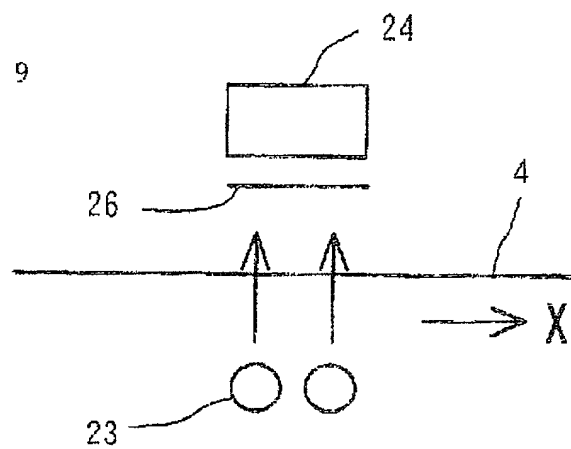
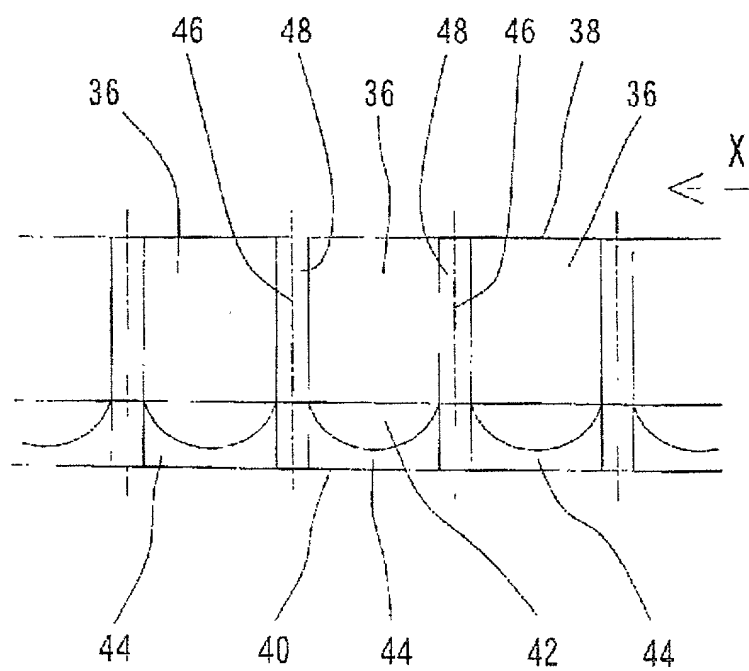


Fig. 10



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Fig. 11

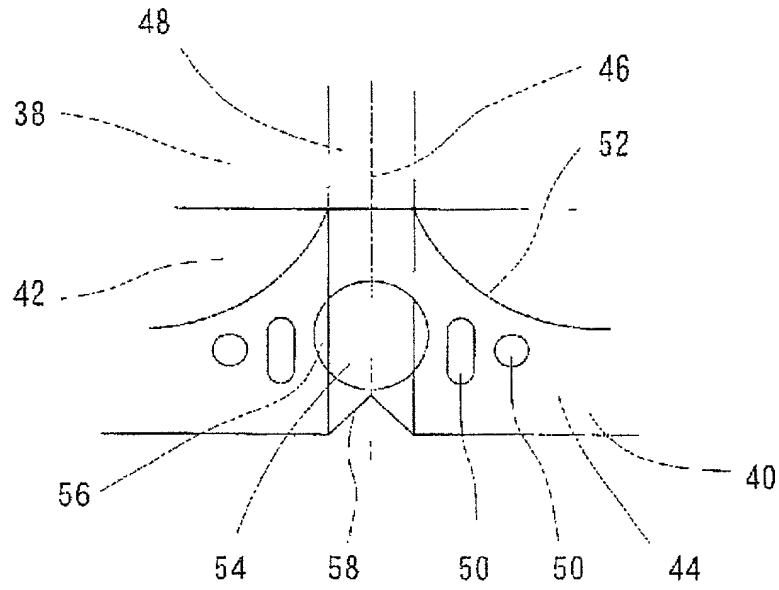


Fig. 12

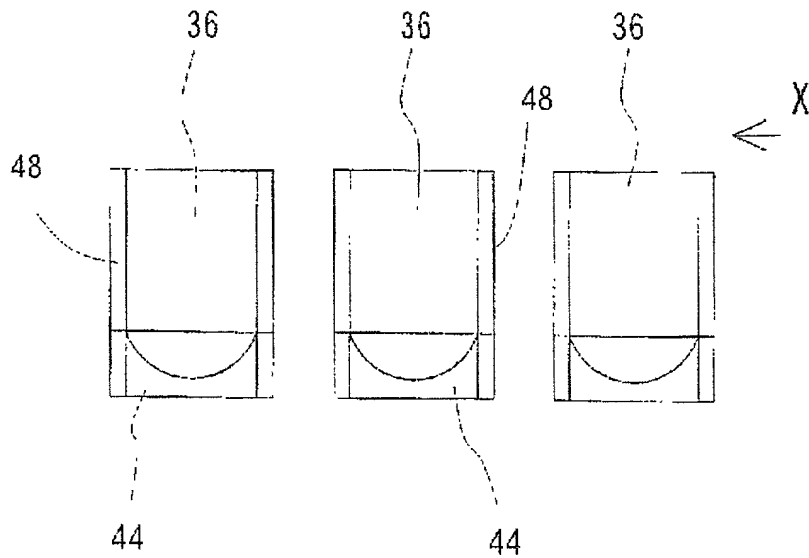


Fig. 13

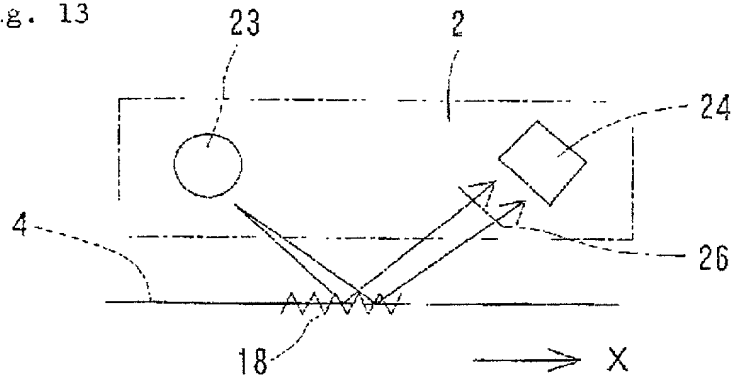


Fig. 14

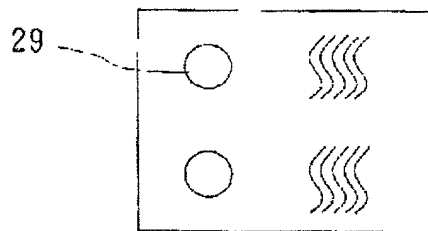


Fig. 15

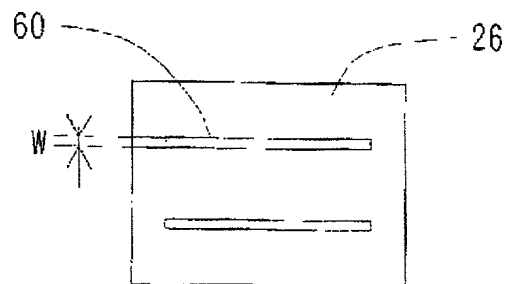


Fig. 16

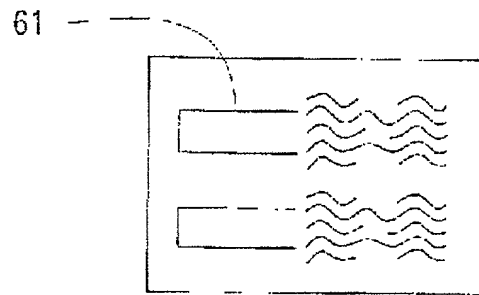


Fig. 17

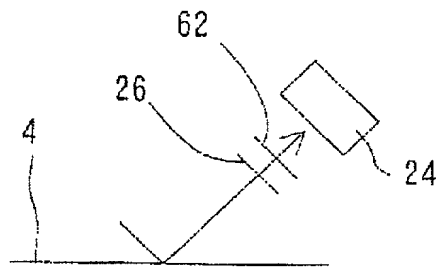
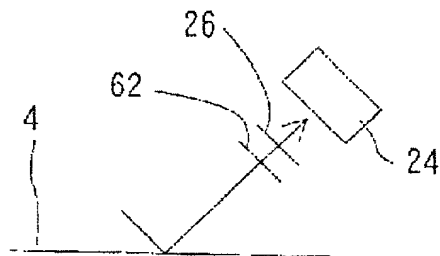


Fig. 18



Docket No. _____

ARMSTRONG, WESTERMAN, HATTORI, McLELAND & NAUGHTON

DECLARATION FOR U.S. PATENT APPLICATION

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention **entitled** (Insert Title) APPARATUS FOR DETECTING
HEAT SEALED PLACES OF PLASTIC FILM MEANS
the specification of which (check one of blocks 1, 2 or 3)

1. ___ is attached hereto.
2. ☒ was filed on October 24, 2000 as
International PCT Application Serial No. PCT/JP00/07437
and was amended on _____.
(if applicable)
3. ___ was filed on _____
U.S. Application Serial No. _____
and was amended on _____.
(if applicable)

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claim(s), as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the examination of this application as defined in Title 37, Code of Federal Regulations, § 1.56.

I hereby claim foreign priority benefits under Title 35, United States Code, § 119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application for which priority is claimed.

Pat. Appln. No. <u>302125 of 1999</u> (Number)	<u>Japan</u> (Country)	<u>25/10/1999</u> (Day/Month/Year Filed)	Priority Claimed <input checked="" type="checkbox"/> Yes ___ No
Pat. Appln. No. <u>374660 of 1999</u> (Number)	<u>Japan</u> (Country)	<u>28/12/1999</u> (Day/Month/Year Filed)	<input checked="" type="checkbox"/> Yes ___ No
Pat. Appln. No. <u>2000-287344</u> (Number)	<u>Japan</u> (Country)	<u>21/09/2000</u> (Day/Month/Year Filed)	<input checked="" type="checkbox"/> Yes ___ No
_____ (Number)	_____ (Country)	_____ (Day/Month/Year Filed)	___ Yes ___ No

See attached list for additional prior foreign applications

I hereby claim the benefit under Title 35, United States Code, § 120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, § 112, I acknowledge the duty to disclose material information as defined in Title 37, Code of Federal Regulations, § 1.56 which occurred between the filing date of the prior application and the national or PCT international filing date of this application.

List Prior U.S. Applications:

(Appln. Serial No.)	(Filing Date)	(Status: Patented, Pending, Abandoned)
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(Appln. Serial No.)	(Filing Date)	(Status: Patented, Pending, Abandoned)
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(Appln. Serial No.)	(Filing Date)	(Status: Patented, Pending, Abandoned)
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And I hereby appoint as principal Attorneys:

James E. Armstrong, III, Reg. No. 18,366; William F. Westerman, Reg. No. 29,988; Ken-Ichi Hattori, Reg. No. 32,861; John R. Pegan, Reg. No. 18,069; William G. Kratz, Jr., Reg. No. 22,631; Le-Nhung McLeland, Reg. No. 31,541; James P. Welch, Reg. No. 17,379; Ronald F. Naughton, Reg. No. 24,616; Albert Tockman, Reg. No. 19,722; Mel R. Quintos, Reg. No. 31,898; Donald W. Hanson, Reg. No. 27,133; Stephen G. Adrian, Reg. No. 32,878; William L. Brooks, Reg. No. 34,129; John F. Carney, Reg. No. 20,276; Edward F. Welsh, Reg. No. 22,455; Patrick D. Muir, Reg. No. 37,403; and Gay A. Spahn, Reg. No. 34,978

Please direct all communications to the following address:

ARMSTRONG, WESTERMAN, HATTORI, McLELAND & NAUGHTON
1725 K Street, N.W., Suite 1000
Washington, D.C. 20006
TEL.: (202) 659-2930
FAX: (202) 887-0357

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under § 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Full name of sole or first inventor TOTANI, Mikio
Inventor's signature Mikio Totani Date June 20, 2001
Residence c/o Totani Corporation
4-44, Nakakuze-cho, Kuze, Minami-ku, Kyoto-shi, Kyoto 601-8213 Japan
Citizenship Japan
Post Office Address c/o Totani Corporation
4-44, Nakakuze-cho, Kuze, Minami-ku, Kyoto-shi, Kyoto 601-8213 Japan

Full name of second joint inventor, if any _____
Inventor's signature _____ Date _____
Residence _____
Citizenship _____
Post Office Address _____

Full name of third joint inventor, if any _____
Inventor's signature _____ Date _____
Residence _____
Citizenship _____
Post Office Address _____

Full name of fourth joint inventor, if any _____
Inventor's signature _____ Date _____
Residence _____
Citizenship _____
Post Office Address _____

Full name of fifth joint inventor, if any _____
Inventor's signature _____ Date _____
Residence _____
Citizenship _____
Post Office Address _____

Full name of sixth joint inventor, if any _____
Inventor's signature _____ Date _____
Residence _____
Citizenship _____
Post Office Address _____

Full name of seventh joint inventor, if any _____
Inventor's signature _____ Date _____
Residence _____
Citizenship _____
Post Office Address _____

NOTES

- A. 1. For declaration to be filed with original U.S. (Non-PCT) Application Papers, check box 1.
2. For declaration to be filed in U.S. National Phase of PCT Application (either with original national phase entry papers or subsequent to expiration of 20 or 30 month term), check box 2, and complete information.
3. For declaration to be filed after original U.S. (Non-PCT) Application filing date, check box 3, and complete information.
- B. Please list all non-convention foreign applications relating to the invention (and check block "no"), as well as convention (priority) applications.
- C. If more than 4 prior foreign applications, please check this box and attach a sheet listing the remaining prior foreign applications.
- D. For the Inventor's "Residence", only the city and state is necessary, however the "Post Office Address" must be an address acceptable by a Post Office for delivery of mail.